

# Work Order ID 57809 -1

Thursday, April 15, 2010 1:17:48 PM



Page 1

Item ID: D3909-041

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010 Start Qty: 6.00

Required Date: 4/30/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3909

A B 10.04.22

100



Packaging

Packaging

Pick Kit

0.00

0.00

Memo

SS 10/04/23

①

110



Small Fab

Small Fab

0.00

0.00

Memo

1- Assemble as per dwg  
Trim rivet to 1.185" long

SS 10/04/23

②

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

SS 10/04/23

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57809**

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Item ID: D3909-041

Accept

Revision ID:

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Required Date: 4/30/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location *SC1*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10-4-23* *SP**10/04/23*  
*MF*  
*10-4-23*



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Work Order ID: 57809

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd


Comments: IPP RevA: New issue DD verified by:EC

Start Date: 4/15/2010

Required Date: 4/30/2010

Start Qty: 6.00


Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	19.0000	6.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST021	19	
50665	19	

D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	6.0000	12.0000			
---	--	--------------	----	--	--	-----	------	--------	---------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ENG	2	
55704	2	
Main Warehouse		
ST095	4	
57118	4	

D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	2.0000	6.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST095	2	
56952	2	

6 SS 10104/23 ①

4510/04/23  
B 578.24 (82)

4  
4510/04/23  
B 578.19 (62)

2

W/O:		WORK ORDER CHANGES					
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Required Date: 4/30/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3909-5  Eyebolt Stud		Manufactured	No			100	Each	0.0000	6.0000			
D3910-1  Crosstube Lug		Manufactured	No			100	Each	12.0000	12.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ENG

57194

12

12

D3917-1



Washer

Manufactured

No

100

Each

6.0000

12.0000

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST096

57298

6

6

AN3C12A



Bolts

Purchased

No

100

Each

224.0000

24.0000

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST351

112314

224

224

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Shop Packet Print

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Work Order ID: 57809



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C13  Bolt		Purchased	No			100	Each	44.0000	6.0000			

*EP 10/04/22*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST351	44	
114304	44	

MS17984-C413

Purchased

No



PIN, QUICK RELEASE

100 Each 9.0000 6.0000



*6*  
*EP 10/04/22*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST297	9	
114340	9	

MS20615-4M20

Purchased

No



RIVET

100 Each 292.0000 18.0000



*3*  
*EP 10/04/22*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST323	292	
113254	16	
114304	22	
114324	54	
114349	200	

*PTO*

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Dart Aerospace Ltd

W/O: 57809-1

### WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/21		change MS20415-4M20 for MS20415-4M18 in 114349	CP	10/04/22	<del>24</del> 24	CP 10.04.21 per QSI 042	

Part No: D 3909-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 57809

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Comments: IPP RevA: New issue DD verified by:EC

Start Date: 4/15/2010

Required Date: 4/30/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN310C3

Purchased

No

100

Each

44.0000

6.0000



Castellated Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST349

44

114304

44

MS21043-3

Purchased

No

100

Each

3,875.000 24.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST301

3795

112314

3795

MS24665-151

Purchased

No

100

Each

716.0000 6.0000



Cotter Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST309

716

17566

716

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Crosstube Lug Assembly, Fwd


Comments: IPP RevA: New issue DD verified by:EC

Start Date: 4/15/2010

Required Date: 4/30/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149C0332R  Washer		Purchased	No			100	Each	5,196.000	60.0000			

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST297

5196

113524

46

113737

150

114341

5000

*EP 10/04/22*

*NAS1149C0363 R*

*Washer*

*10.04.22*

*Qty: 12*

*Seq 100*

*Batch: 113422*

*12X*

*EP 10/04/22*

*\* Was change on Rev 10.04.20  
as per Rev B.*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

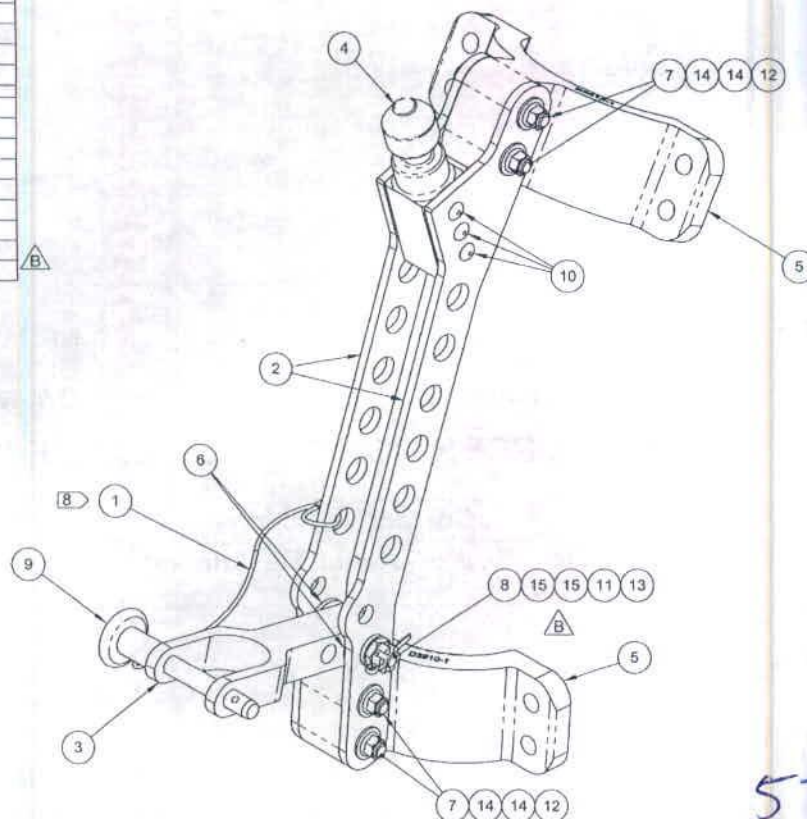
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**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



**D3909-041 FWD X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

**RELEASED**  
2010-04-07

57809

BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED. ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED. SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW. ADDED. DIM: 2.88 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05. WEIGHT REVISED.		JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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**NOTE:** Date & initial all entries

D3910-1  
X-TUBE LUG  
2 PL

D2690-6  
LANYARD

MS17984-C413  
PIP PIN

D3917-1  
WASHER

D3909-5  
EYEBOLT STUD

MS20615-4M20  
RIVET  
3 PL

D3909-1  
FWD X-TUBE LUG PLATE  
2 PL

D3909-3  
FWD LOWER ATTACH ARM

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043-3 NUT  
4 PL

AN3C13 BOLT  
NAS1149C0363R WASHER, 2X  
AN310C3 NUT - CASTELLATED  
MS24665-151 COTTER PIN

# D3909-041 FWD X-TUBE LUG ASSY

**RELEASED**  
2010-04-07  
MP

57809

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3909	REV. B
MFG. APPR.	JPH	TITLE FWD X-TUBE LUG ASSY	SHEET 2 OF 5
APPROVED	JPH	SCALE NTS	
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ISSUED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

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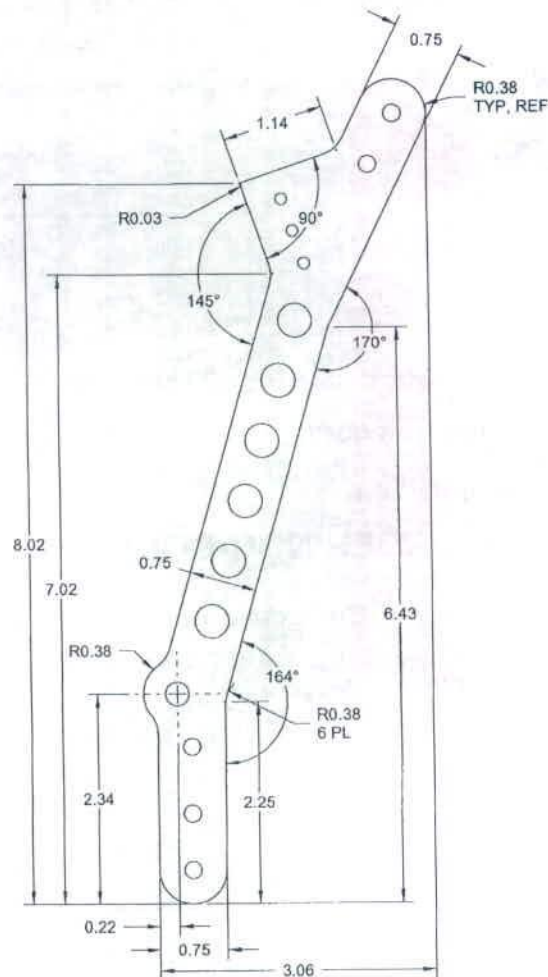
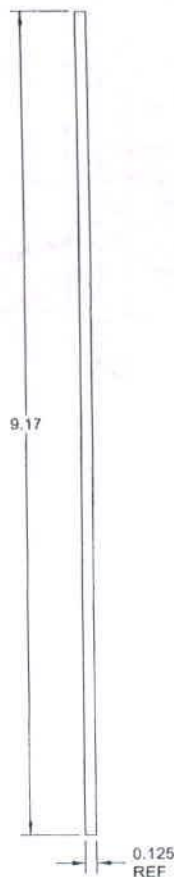
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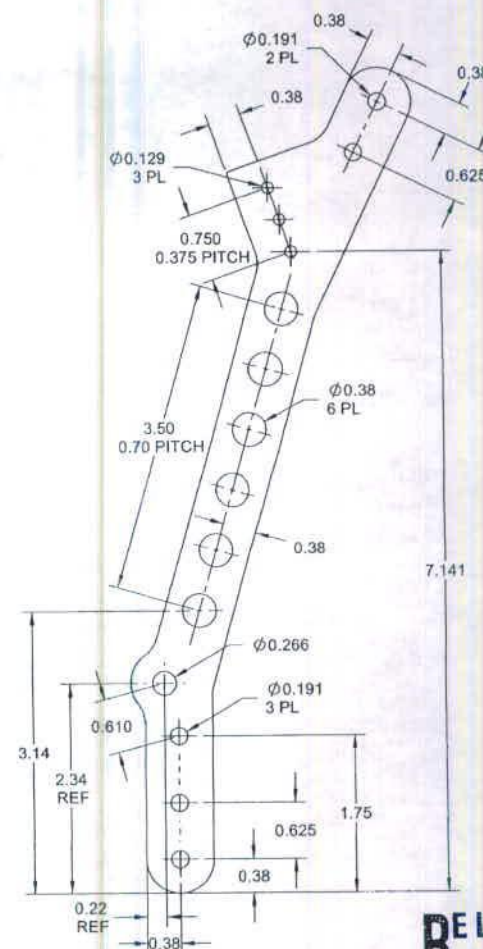
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**D3909-1 FWD X-TUBE LUG PLATE**



(SUPPLEMENTAL VIEW)

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

57809

**RELEASED**  
2010-04-07  
MP

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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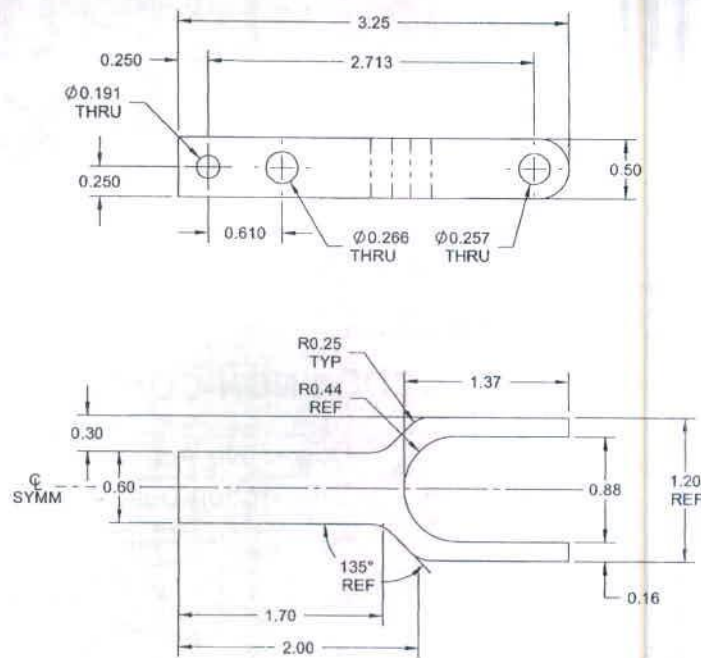
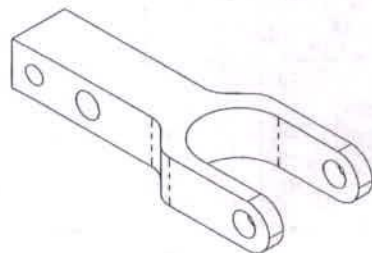
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**D3909-3 FWD LOWER ATTACH ARM**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

57809

**RELEASED**  
2010-04-07  
MD

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3909	SHEET 4 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

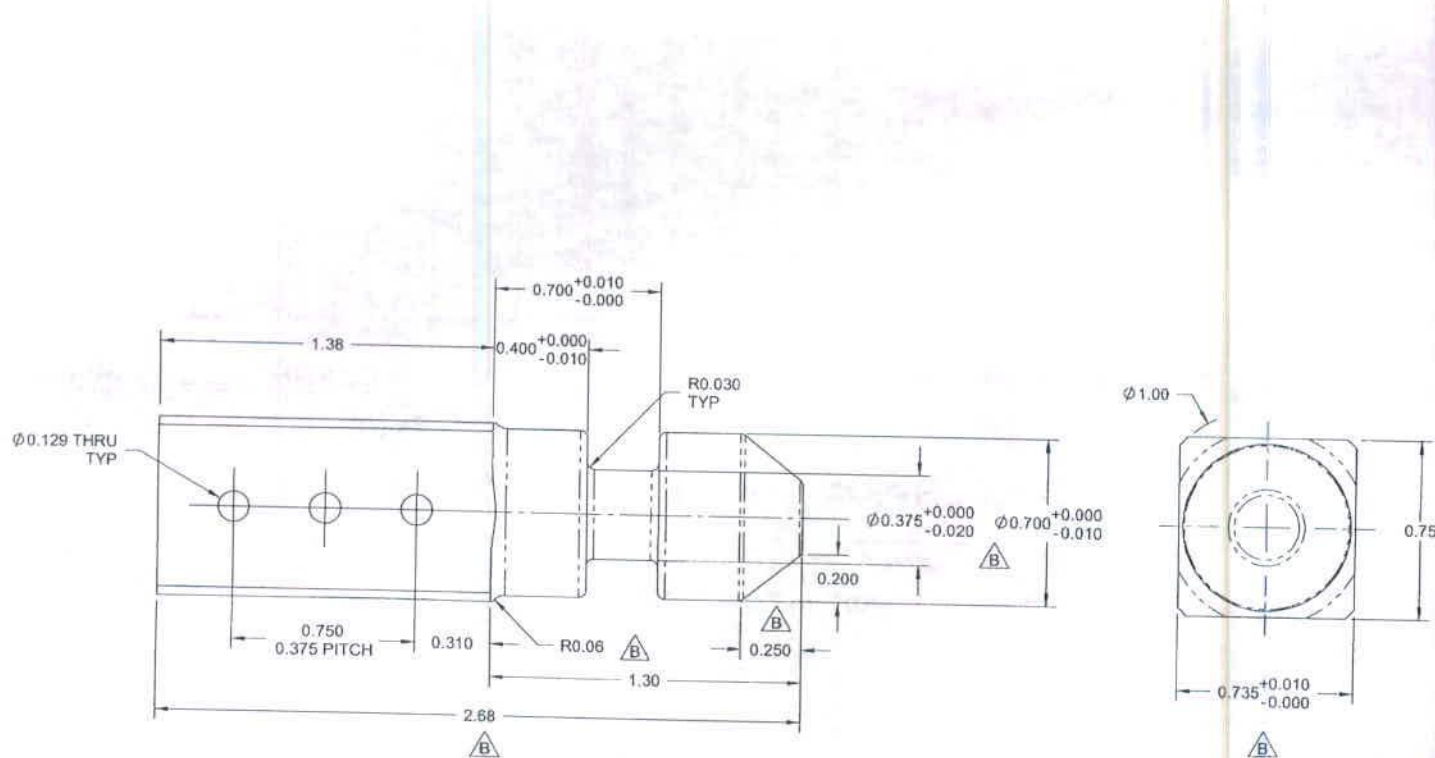
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



D3909-5 EYEBOLT STUD

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NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

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